

**Work Order ID 57746**

April 14, 2010 11:37:05 AM



Page 1

Item ID: D3594-044

Accept



Setup Start



Revision ID:

Item Name: Floor Doubler Assembly, RH

Stop



Start Date: 14/04/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: *H*

Date: 10-4-14

Tooling:

Date:

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr								
D3594	Rev B								

100



FLOW WATER JET

Waterjet

Memo

0.00

B 10-S-6

FLOW CNC Waterjet

1-Cut as per Dwg D3594  Dwg Rev: *B*  Prog Rev: *B*  2-  
Deburr if necessary

6661 . 680

(15)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

B 10-S-6

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

Swatoslo

QC

Memo

0.00

Quality Control

(x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 57746**

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Page 2

Item ID: D3594-044

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Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center ID

130



Small Fab

Operation  
Description

Small Fab

Set Up/  
Run Hours

0.00

Draw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Small Fab

Memo

0.00

Small Fab

C'SINK AS PER DWG D3594

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8.10/05/10

0.00

X5

-1

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

15

BR 10-5-11

W/O:			WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No: _____			PAR #: _____	Fault Category: _____	NCR: Yes	No	DQA: _____	Date: _____	
Resolution			Disposition: _____		QA: N/C Closed: _____		Date: _____		
NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
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**Work Order ID 57746**

April 14, 2010 11:37:05 AM



Page 3

Item ID: D3594-044

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Revision ID:

Item Name: Floor Doubler Assembly, RH

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Start Date: 14/04/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

MF

16/05/11

15

6

170



Small Fab

Small Fab

0.00

Small Fab

Memo

0.00

Install Nut Plates As per Dwg D3594

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

S. 10/05/11.2

415

-044

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

**Work Order ID 57746**

April 14, 2010 11:37:05 AM



Page 4

Item ID: D3594-044

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Item Name: Floor Doubler Assembly, RH

Stop



Start Date: 14/04/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

190

Identify as per dwg & Stock Location: 234BSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Packaging

Packaging

Memo

0.00

10-5-12



200



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

10/05/17 JJ

BJO-5-13

(15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

April 14, 2010 11:37:09 AM

Page 1

Work Order ID: 57746



Parent Item: D3594-044



Parent Item Name: Floor Doubler Assembly, RH

Start Date: 14/04/2010

Required Date: 22/04/2010

Comments: IPP Rev :A New Issue 07-01-22 EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS20426AD4-4



Purchased

No

100

Each

1,872.000

20.0000



Rivet

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST316

1872

15541

1872

M6061T6S.080



Purchased

No

170

sf

290.7512

5.3684



6061-T6 .080 Sheet

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

MAT21

290.7512

113438

2.7512

114351

288

MS21069-5



Purchased

No

170

Each

65.0000

10.0000



Anchor nuts

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST302

65

113725

50

114075

15

*BB/05/11*

30

8.1

B10-S-6

(15)

114351

*BB/05/11*

15

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	57746
Description: Floor Doubler, RH.	Part Number:	D3594-4
Inspection Dwg: D3594      Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>PB</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	10-5-16	Date:	10/05/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue P/O D3594-044	KJ/JLM	
B	09.05.07	Dimensions updated per Dwg Rev B	KJ/EC	

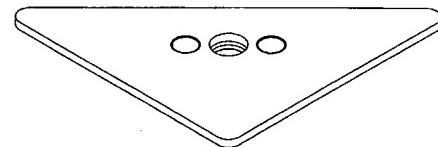
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

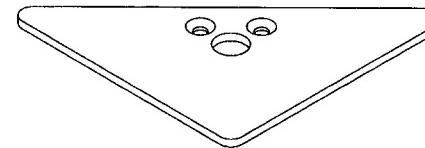
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

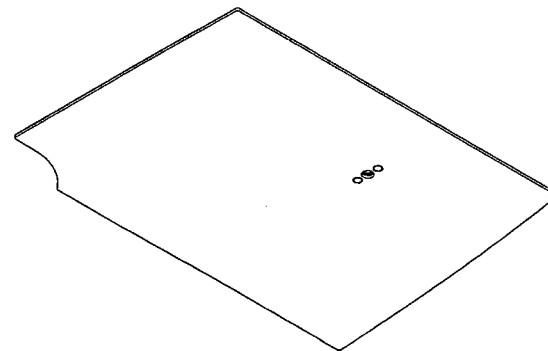
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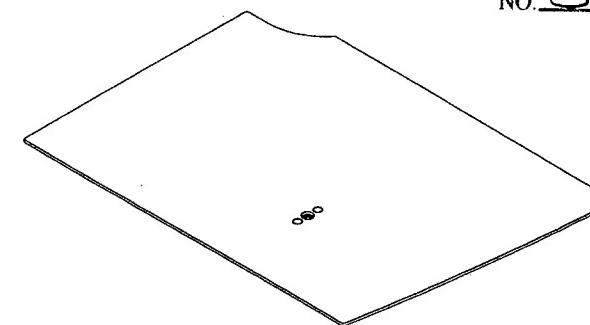
D3594-041 DOOR DOUBLER ASSEMBLY



D3594-5 DOOR DOUBLER



D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 57744

*PA 10-4-44*

**RELEASED**  
*08-06-26*

B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD -5.	AJS	08.05.14
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION		
DESIGN	MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.05.14	REV. B	SHEET 1 OF 4
		TITLE	SCALE
		DOUBLER	NTS
		COPYRIGHT © 2007 BY DART AEROSPACE LTD THE DOCUMENT CONTAINED HEREIN IS THE PROPERTY OF DART AEROSPACE LTD AND IS EXCLUDED FROM THE CIRCUMSTANCES CONCERNING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No: _____		PAR #: _____	Fault Category: _____	NCR: Yes No	DQA: _____	Date: _____			
Resolution: _____		Disposition: _____			QA: N/C Closed: _____	Date: _____			
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date &amp; initial all entries

8

7

6

5

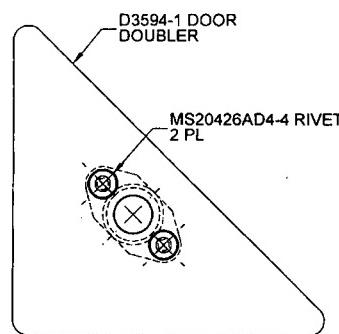
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3

2

1

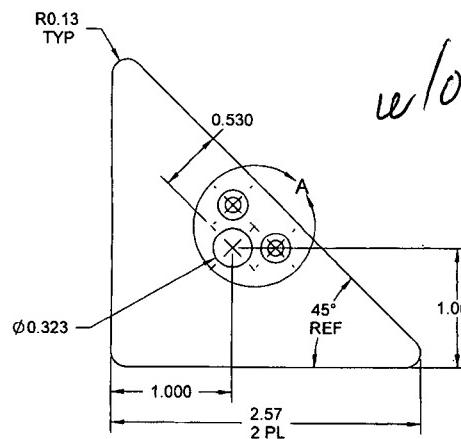
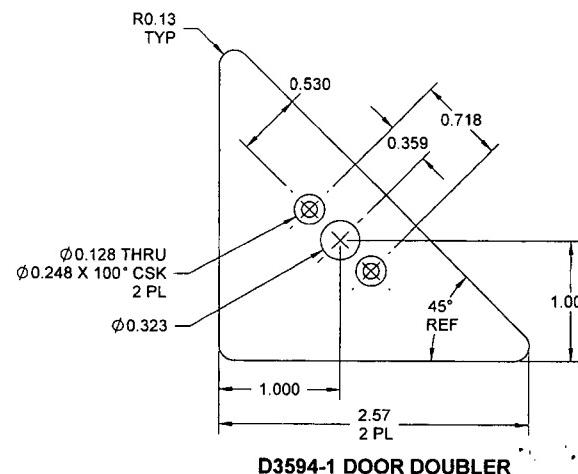
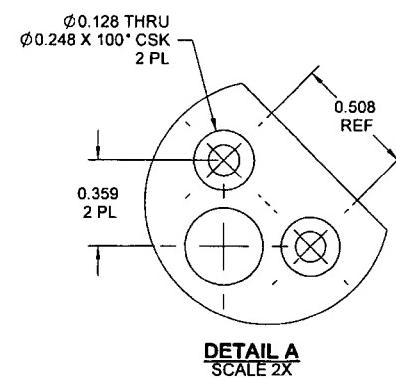
QTY. -041	PART NUMBER	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069L5	ANCHOR NUT
2	MS20426AD4-4	RIVET, CSK



④ D3594-041 DOOR DOUBLER ASSEMBLY

NOTES:

- 1) MATERIAL: -1 & -5  
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) IDENTIFY WITH DART P/N "D3594-5" USING FINE POINT PERMANENT INK MARKER
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -041: 0.04 lbs  
-5: 0.03 lbs



⑤ D3594-5 DOOR DOUBLER A

RELEASED  
08.05.14

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AUS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	08.05.14	COPRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No: _____		PAR #:	Fault Category:	NCR: Yes No		DQA:	Date:		
Resolution:		Disposition:			QA: N/C Closed:		Date:		
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date &amp; initial all entries

8 7 6 5 4 3 2 1

QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	X	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
1		D3594-3	FLOOR DOUBLER, LH
1		D3594-4	FLOOR DOUBLER, RH
1	1	MS21069L5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET, CSK

D

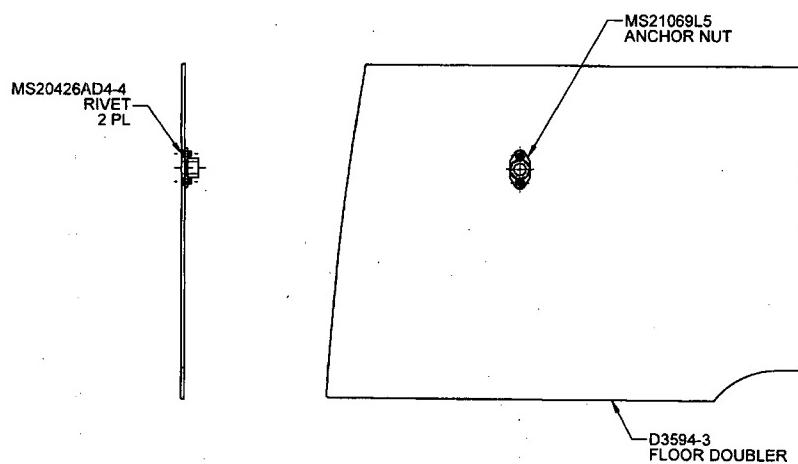
D

C

C

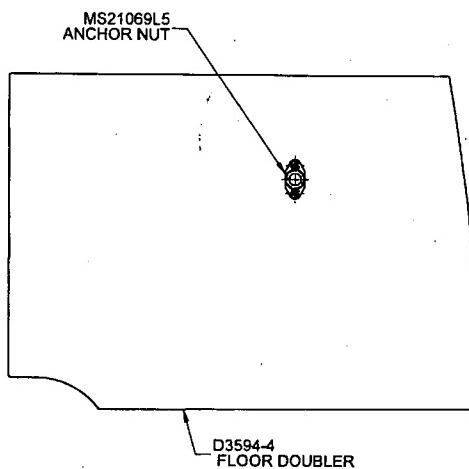
B

B

D3594-043 FLOOR DOUBLER ASSEMBLY

## NOTES:

- 1) MATERIAL: -3 & -4  
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -043 & -044: 0.80 lbs

D3594-044 FLOOR DOUBLER ASSEMBLY

w/0 57746

RELEASED  
08-06-14

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		REV. B	
MFG. APPR.		DRAWING NO. D3594	
APPROVED		SHEET 3 OF 4	
DE APPR.		TITLE	SCALE
DATE 08.05.14		DOUBLER	NTS

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8 7 6 5 4 3 2 1

A

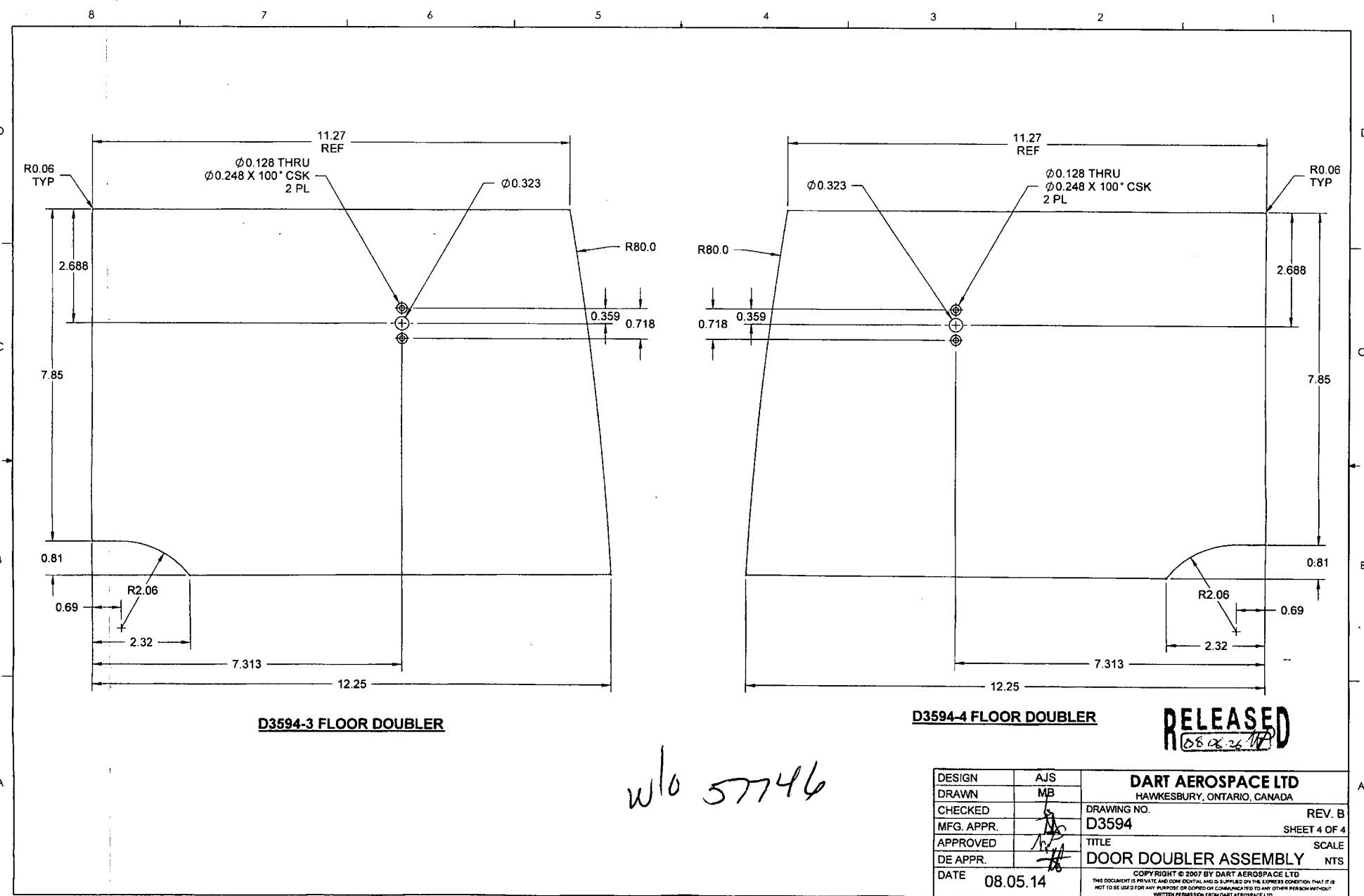
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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3594-4 FLOOR DOUBLER

RELEASED  
08/26/14

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	D3594
APPROVED	<i>[Signature]</i>	REV. B
DE APPR.	<i>[Signature]</i>	SHEET 4 OF 4
DATE	08.05.14	TITLE
		DOOR DOUBLER ASSEMBLY
		SCALE
		NTS
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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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